DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 99.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-027035
Date Inspected: 06-Jan-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Watson Bowman Acme,

OSM Arrival Time: 700
OSM Departure Time: 1530
Location: Amherst NY

CWI Name:	Reno Davis, KTA Tator			**CWI Present:**	☑ Yes	☐ No	
Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Approved WPS:**	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☐ No	☑ N/A

Bridge No: 34-0006
Component: Channel Assemblies, Deck Plates

Summary of Items Observed:

Seismic Expansion Joint Hinge A lanes for the San Francisco Oakland Bay Bridge (SFOBB) project.

This (QAI) Inspector met with Watson Bowman Acme Corporation (WBA) Quality Control (QCS) Supervisor John Miller and Certified Welding Inspector (CWI), Mr. Reno Davis.Quality Control personnel for this location.

This QAI arrived at WBA and observed Joe Kearns performing Flux Core Arc Welding (FCAW) on components SEI112667-CA2-21, using Hobart (Tri-Mark) TM-811N1 electrode under WPS's FCAW-NY-16 (CJP for Joint TC-U5a-GF). Weld parameters were set and verified by Mr. Davis before welding was started. All parameters are within approved WPS requirements. The welder was observed using a rose bud torch to pre-heat the areas to 110 degrees Celsius (225F). The weld joints being welded by Joe Kearns at the end plate were 2-6 C-F with reinforcing 8mm fillet welds. These welds on the channel boxes join the partition plates to the bottom plate. Watson Bowman welder Jayson Gray was observed setting up the next channel assembly SEI112667CA2-22. Bottom plate was set on table and laid out for back plate, end plates and divider plate locations per approved drawing B-24952 sheet 5 of 12 Rev 12.

Welder John Ash is in the process of cleaning finished channel assemblies SEI112667CA2- 19 and 20. Anchor studs were welded on second shift 1/5/12. This QAI visually witnessed the inspection of the attachment welds of the studs to base material by Mr. Davis as well as verified adhesion with bend tests on random studs. Channel assemblies are complete.

The last (4) Deck Plates, SEI112667AC- 20, 22, 23 & 24 were received at Watson Bowman Acme from KDM Die

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Company, 620 Elk St. Buffalo NY. Plates were previously Green tagged by Ken Riley for shipment to WBA. Condition received at WBA is acceptable per inspection by this QAI. John Ash then started with plate SEI112667AC-22 to attach lifting lugs to top of plate as required by approved drawing B-24952 sheet 10 of 12 and sheet 12 of 12. A 6mm fillet weld per approved WPS SMAW-11 is required for each side of the lug to deck plate. Welding was performed per specifications set by WPS and monitored by this QAI.

The items observed appear to be progressing as scheduled and are in general conformance with the contract documents.

Summary of Conversations:

Basic conversation, fundamental to completion of the tasks at hand, occurred between this QAI, ABF QC and WBA Personell.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Sullivan,Kevin	Quality Assurance Inspector
Reviewed By:	Foerder,Mike	QA Reviewer